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(54) **ULTRAPURE HYPOALLERGENIC SOLUTIONS OF SACROSIDASE**

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(58) **Field of Classification Search**

CPC **A61K 38/46**; **A61K 38/43**
See application file for complete search history.

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ABSTRACT

One aspect provides an ultrapure, hypoallergenic sacrosidase. Another aspect provides a solution of sacrosidase in about 1:1 glycerol/water having an enzymatic activity of at least about 7500 IU/mL and a residual papain concentration that does not include an allergic reaction in a human patient when given a dose of about 2.0 mL/day.

5 Claims, 5 Drawing Sheets

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Figure 1 Flow Diagram of the Manufacturing Process

Step / Equipment	Materials	Process Control	Outputs
1. Digestion of yeast in (1000 gal reactor)	<ul style="list-style-type: none"> » deionized water (filtered) » yeast » sodium hydroxide, 25% solution » papain (100 TU/mg) » hydrogen peroxide 	30° - 34°C pH = 7 ± 0.1 Hold 17.5 to 22 hours	Mixture with cell debris and dissolved proteins.
2. Acidification of digest	<ul style="list-style-type: none"> » phosphoric acid, 85% » diatomaceous earth 	22° - 26°C pH = 4.0 ± 0.1	Mixture with cell debris and dissolved proteins. Papain inactivated.
3. Removal of Cell Debris (Sparkler filter)	<ul style="list-style-type: none"> » deionized water (filtered) » filter paper 	30° - 25°C	Protein solution.
4. Decolorization of filtrate	<ul style="list-style-type: none"> » activated carbon » hydrogen peroxide solution » aluminum sulfate » diatomaceous earth » filter paper 	23° - 27 °C Hold 30-60 minutes.	Mixture with carbon, aluminum hydroxide floccules, and dissolved proteins.
5. Removal of Solids (Sparkler filter)		No more than a trace amount of carbon remaining in liquid. Filter in-line through a 0.2 micron filter.	Clarified protein solution.
6. Concentration via Ultrafiltration (Ultrafiltration Rig)	<ul style="list-style-type: none"> » 40 kDa Molecular Weight Cut-Off polyethersulfone filter membrane 	22°-28°C; sufficient volume reduction for batch to fit in UF rig.	Concentrated Sacrosidase solution (~250 L)
7. Diafiltration followed by concentration (Ultrafiltration Rig)	<ul style="list-style-type: none"> » deionized water (filtered) » sodium citrate » citric acid » sodium hydroxide, 25% 	pH=4.6 ± 0.1 Target sucrose activity of ≥ 22,000 IU/mL.	Concentrated, ultra-pure Sacrosidase solution. Papain concentration substantially reduced.
8. Adjust pH (1000 L Tote w/ Recirculating Pump)	<ul style="list-style-type: none"> » phosphoric acid, 85% or » sodium hydroxide, 25% 	pH=4.3 ± 0.1	Concentrated Sacrosidase with optimal pH
9. Blending with Glycerin	<ul style="list-style-type: none"> » glycerin 	Target sucrose assay value of >10,000 IU/mL and a glycerin content of 45 to 54% by weight.	Concentrated Sacrosidase solution, containing glycerin.
10. Filtration into HDPE Drums	<ul style="list-style-type: none"> » Filter in-line through two 0.2 micron filters in series. 		Filtered, concentrated Sacrosidase solution, containing glycerin.

Figure 2

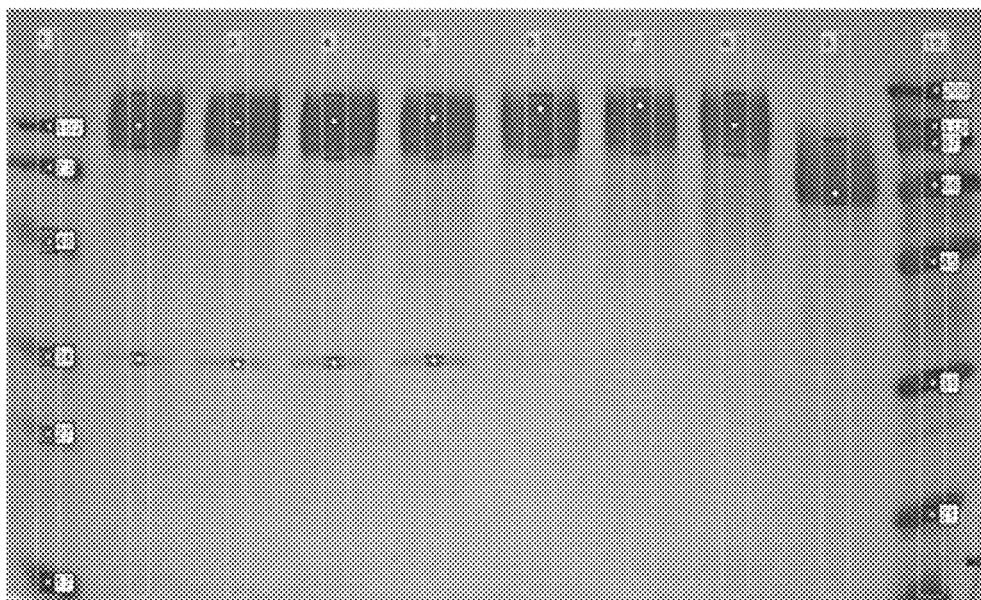


Figure 1. Optimal Loaded SDS-PAGE Stained with Coomassie

Sacrosidase bulk drug substance from two manufacturers (5 µg). Lane 1: Low range MW marker; Lane 2: Reference Standard C4546; Lane 3: STS-199NS; Lane 4: STS-220NS; Lane 5: STS-241NS; Lane 6: 125275; Lane 7: 125434; Lane 8: 125722; Lane 9: Reference Standard C3955; Lane 10: Broad range MW marker.

Figure 3

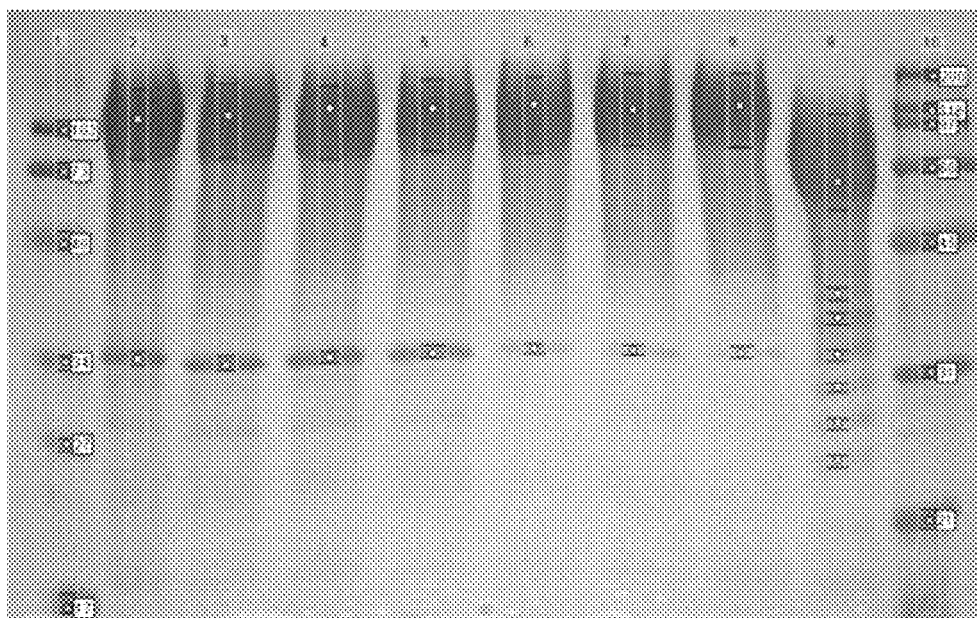


Figure 1. Overloaded SDS-PAGE Stained with Coomassie

Sacrosidase bulk drug substance from two manufacturers (20 μ g). Lane 1: Low range MW marker; Lane 2: Reference Standard C4546; Lane 3: STS-199NS; Lane 4: STS-220NS; Lane 5: STS-241NS; Lane 6: 125275; Lane 7: 125434; Lane 8: 125722; Lane 9: Reference Standard C3955; Lane 10: Broad range MW marker.

Figure 4

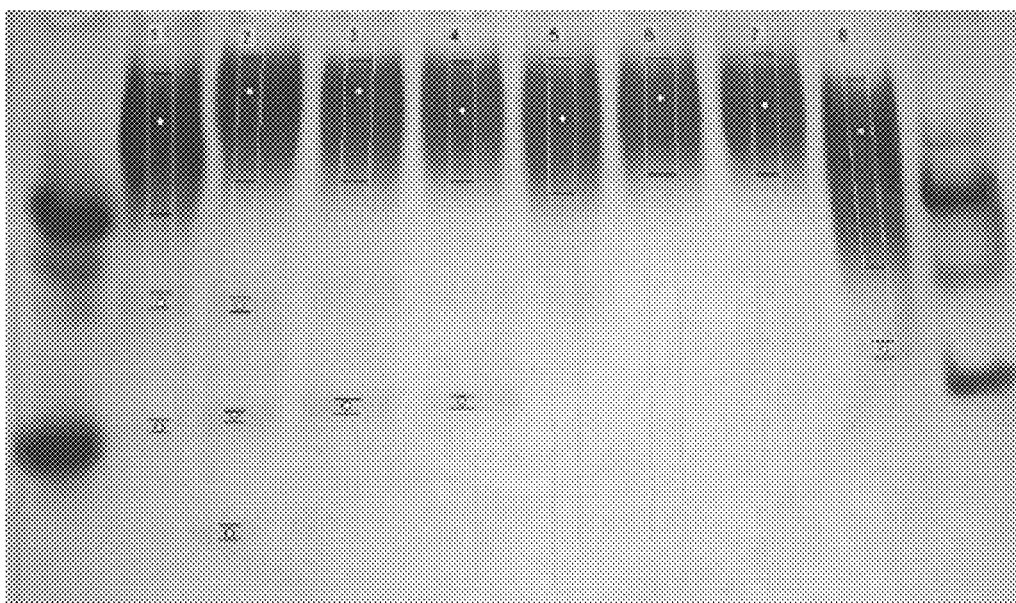


Figure 1. Overloaded Native Stained with Coomassie

Sacrosidase bulk drug substance from two manufacturers (15 μ g). Lane 1: Reference Standard C4546; Lane 2: STS-199NS; Lane 3: STS-220NS; Lane 4: STS-241NS; Lane 5: 125275; Lane 6: 125434; Lane 7: 125722; Lane 8: Reference Standard C3955.

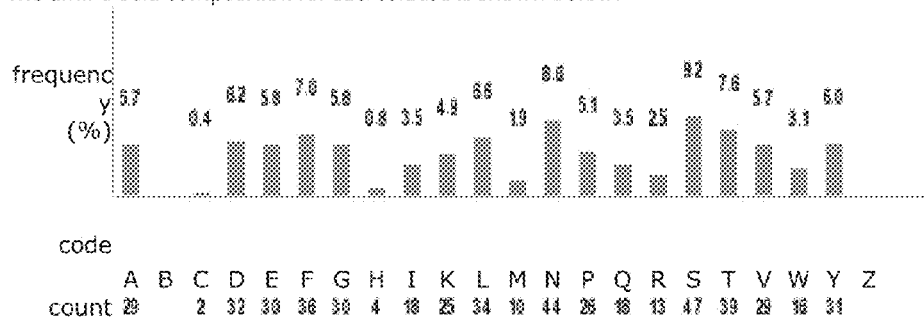
Figure 5

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1  SMTNETSDRP LVHFTFNKSW MNDPENGWYD EKDAKWHLYF QYNPNDTVWG
51  TPLFWGHATS DDLTNWBDQP IAIAPKRNDG GAFSGSMVVD YNNTSGFFND
101 TIDPRQRCVA IWTYNTPESE EQYISYSLDG GYTFTEYQKN PVLAANSTQF
151 RDPKVFWEYEP SQKWIMTAAK SQDYKIBIYS SDELKSWKLE SAFANEGFLG
201 YQYECPLIE VPIEQDPSKS YWVMFISINP GAPAGGSFNQ YFVGSFNGIR
251 FEAFDNQSRV VDFGKDYYAL QTFNTDPTY GSALGIAWAS NWEYSAPVPT
301 NPWRSSMSLV RKFSLNTEYQ ANPETELINL KAEPILNIN AGPWSRFATN
351 TTLTKANSYN VDLNSTGTTL EFELVYAVNT TQTISKSVFA DLSLWPKGLE
401 DPPEYLRMGF EVSASSFFLD RGNSKVKFVK ENPYFTNRMS VNNQPFKSEN
451 DLSYYKVYGL LDQNIILEYF NDGDVVSTNT YFMTIGNALG SVNMTIGVDN
501 LFYIDKQVR EVK

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The amino acid composition for sacrosidase is shown below.



Number of residues = 513

Molecular weight = 58631.39

A	Ala	89.09	G	Gly	75.07	N	Asn	132.12	V	Val	117.15
B	Asx	132.61	H	His	155.15	P	Pro	115.13	W	Trp	204.23
C	Cys	121.15	I	Ile	131.17	Q	Gln	146.15	Y	Tyr	181.19
D	Asp	133.10	K	Lys	146.19	R	Arg	174.20	Z	Glx	146.64
E	Glu	147.13	L	Leu	131.17	S	Ser	105.09			
F	Phe	165.19	M	Met	149.21	T	Thr	119.12	X	ala	128.16

The molecular formula for Sacrosidase, based on the amino acid composition, is

$C_{7662}H_{4909}N_{863}O_{1329}S_{12}$.

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ULTRAPURE HYPOALLERGENIC SOLUTIONS OF SACROSIDASE

BACKGROUND OF THE INVENTION

Congenital sucrose-isomaltase deficiency (CSID) is a chronic, autosomal recessive, inherited, phenotypically heterogeneous disease with variable enzyme activity. CSID is usually characterized by a subject having complete or almost complete lack of endogenous human sucrase activity, along with a very marked reduction in isomaltase activity, a moderate decrease in maltase activity, and the subject can have normal or abnormal lactase levels.

The human enzyme sucrase-isomaltase is naturally produced in the brush border of the small intestine, primarily the distal duodenum and jejunum. The natural human enzyme hydrolyzes the disaccharide sucrose into its component monosaccharides, glucose and fructose. Isomaltase breaks down disaccharides from starch into simple sugars.

In the absence of endogenous human sucrase-isomaltase enzyme, as in CSID, sucrose is not metabolized. Unhydrolyzed sucrose and starch are not absorbed from the intestine and their presence in the intestinal lumen leads to osmotic retention of water. This may result in loose stools or diarrhea. Unabsorbed sucrose in the colon is fermented by bacterial flora to produce increased amounts of hydrogen, methane and water. As a consequence, excessive gas, bloating, abdominal cramps, nausea, vomiting, and explosive diarrhea may occur. Chronic malabsorption of disaccharides may result in malnutrition. Undiagnosed/untreated CSID patients often fail to thrive and fall behind in their expected growth and development curves. Prior to the FDA approval of the commercial replacement product Sucraid® (sacrosidase) Oral Solution, the treatment of CSID has required the continued use of a strict sucrose-free diet with limited success in disease management.

CSID is currently treated by the oral administration, with meals, of a glycerol-water (1:1 w/w) solution of sacrosidase, which provides the enzyme replacement therapy for CSID. This solution is commercially provided as Sucraid® (sacrosidase) Oral Solution distributed by QOL Medical LLC. Each milliliter (mL) of Sucraid® contains 8500 International Units (I.U.) of the enzyme sacrosidase, the active ingredient. The chemical name of this enzyme is β -D-fructofuranoside fructohydrolase. The enzyme is derived from baker's yeast (*Saccharomyces cerevisiae*), by enzymatic digestion with papain.

The Sucraid® product was typical of the era with respect to purity. The FDA established purity specification was not less than 85% in the main band(s) by reduced SDS-PAGE densitometry analysis following Coomassie staining. This is a band ratio of sacrosidase to other proteins of about 6:1.

The purity was specified by the FDA to comprise not more than 10 μ g/mL of papain in the sacrosidase drug substance. The "drug substance" is the precursor glycerol:water solution of sacrosidase that can be further diluted and packaged to yield Sucraid®, which is referred to as the finished "drug product." The original label approved by FDA in 1998 made notice of potential for allergic reactions, and cautioned doctors to treat CSID patients for the first time within their unit in case allergic reactions arose. Again, in 2008, as the result of a site change of the drug substance manufacturer, the FDA only approved the re-launch of this drug with the imposition of a Risk Evaluation and Mitigation Strategy (REMS) which are only required by the FDA for drugs with the potential for serious safety problems.

It has been reported that the primary structure of sacrosidase consists of 513 amino acids with an apparent molecular

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weight of 100,000 g/mole for the glycosolated monomer (range 60,000-116,000 g/mole). Reports also suggest that the protein exists in solution as a monomer, dimer, tetramer, and octomer ranging from 100,000 g/mole to 800,000 g/mole. It has an isoelectric point of 4.1 (pI=4.093).

Presently, Sucraid® is provided in bottles containing 118 mL of the sacrosidase solution. A typical dose is either 1 or 2 mL with every meal or snack. The solution is bottled aseptically; however, it may become contaminated after opening due to the necessity of frequent administration, so patients are instructed to discard the bottle 4 weeks after opening.

SUMMARY OF THE INVENTION

This invention provides an ultrapure hypoallergic sacrosidase that meets the pharmaceutical standards for human prescription use. The sacrosidase is also organoleptically improved, since aqueous solutions thereof are odorless.

One embodiment provides a protein composition consisting of sacrosidase and containing no other proteins as determined by SDS-PAGE of up to about 15 μ g of said composition. Techniques of SDS-PAGE, as described herein below, can employ reducing conditions and Coomassie Blue Staining. Thus, one embodiment provides a protein composition consisting essentially of sacrosidase having a band volume ratio of sacrosidase to other proteins of at least about 35:1, e.g., about 35-55:1, as determined by SDS-PAGE of about 20 μ g of said composition. The protein composition of one embodiment is produced by a process comprising diafiltration of the yeast digest and does not employ chromatographic purification of said sacrosidase.

Another embodiment provides a drug substance and a drug product consisting essentially of a solution of sacrosidase in water comprising about 45-54 wt-% glycerol and that contains less than about 10 ng/mL, preferably less than about 3.0 ng/mL of papain in combination with at least about 7500 IU/mL of sacrosidase. One embodiment provides a solution consisting essentially of at least about 7500-9500 IU/mL, preferably about 8500 IU/mL sacrosidase in about 1:1 glycerol:water that contains less than about 3.0 ng/mL papain. This sacrosidase formulation does not induce an allergic reaction in a human subject such as a CSID patient, when administered at a dose of up to about 2.0 mL (daily doses of 2-10 mL).

Another embodiment provides a sacrosidase solution in water/glycerol having an activity of at least about 10,000 IU/mL and having less than about 10 ng/mL residual papain. In one embodiment, the solution has about a 1:1 wt-wt ratio of water to glycerol. In another embodiment, the solution has a pH of about 4.1-4.5.

The amount of papain can be determined by the techniques of ELISA. The solution is also not produced by a process comprising chromatographic purification of said sacrosidase.

As used herein the term "about" is intended to encompass variation in the referenced parameter, such as concentration, pH, enzymatic activity, time and the like that would be recognized by the art worker as necessarily inherent in determination of the parameter, e.g., see FIG. 1.

Additional information about Sucraid® and sacrosidase can be found in U.S. patent application Ser. No. 13/786,956, filed Mar. 6, 2013, which is incorporated by reference herein.

BRIEF DESCRIPTION OF THE FIGURES

FIG. 1 is a flow diagram of the current sacrosidase drug substance manufacturing process.

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FIG. 2. Optimal Loaded SDS-PAGE gel Stained with Coomassie Blue. Sacrosidase bulk drug substance (FIG. 1) from two manufacturers (5 µg protein). Lane 1: Low range MW marker 17, 28, 34, 40, 73 and 102 kD; Lane 2: Reference Standard C4546; Lane 3: STS-199NS; Lane 4: STS-220NS; Lane 5: STS-241NS; Lane 6: 125275; Lane 7: 125434; Lane 8: 125722; Lane 9: Reference Standard C3955; Lane 10: Broad range MW marker (21, 34, 45, 66, 97 kD and 200 kD).

FIG. 3. Overloaded SDS-PAGE gel Stained with Coomassie. Sacrosidase bulk drug substance from two manufacturers (20 µg protein). Lane 1: Low range MW marker; Lane 2: Reference Standard C4546; Lane 3: STS-199NS; Lane 4: STS-220NS; Lane 5: STS-241NS; Lane 6: 125275; Lane 7: 125434; Lane 8: 125722; Lane 9: Reference Standard C3955; Lane 10: Broad range MW marker.

FIG. 4. Overloaded Native gel stained with Coomassie. Sacrosidase bulk drug substance from two manufacturers (15 µg protein). Lane 1: Reference Standard C4546; Lane 2: STS-199NS; Lane 3: STS-220NS; Lane 4: STS-241NS; Lane 5: 125275; Lane 6: 125434; Lane 7: 125722; Lane 8: Reference Standard C3955.

FIG. 5. The primary amino acid structure of Sacrosidase consists of 513 amino acids. Sacrosidase has the amino acid sequence shown below (SEQ ID NO:1).

DETAILED DESCRIPTION OF THE INVENTION

This invention provides an ultrapure hypoallergenic sacrosidase that meets the pharmaceutical standards for human prescription use, with reduced allergenic properties. The sacrosidase is also organoleptically improved, since aqueous solutions thereof are odorless. Solutions of sacrosidase that are less pure can exhibit unpleasant organoleptic properties, such as a "yeasty" smell, unappetizing color and other odors. Common Names: Invertase, Sacrosidase

Trade Name:	Sucraid® (sacrosidase) oral solution (Drug Product)
USAN:	Sacrosidase
Chemical:	β-D-fructofuranoside fructohydrolase
Synonyms:	β-D-fructofuranosidase β-D-fructofuranosidase β-fructofuranosidase β-fructofuranoside fructohydrolase β-fructopyranosidase β-fructosidase β-invertase Fructosylinvertase Invertase Invertin Glucosucrase Saccharase Sucrase Sucrose hydrolase Exo-β-(2,6)-Fructofuranosidase Maxivert L 1000 Yeast Sucrase (YS)
CAS Number:	85897-35-4 9001-57-4

Summary of the Purification Process

This invention provides a chromatography free process to produce ultrapure sacrosidase protein that meets pharmaceutical standards for human prescription use. Never before has a non-chromatographic method been developed to produce such ultra-high purity protein, particularly sacrosidase, overcoming prior shortcomings due to inadequate purity. A non-chromatographic purification process engenders significant cost and time savings during manufacturing. Provided herein is study drug characterization, purity evidence, and finally clinical proof of the improved unique hypoallergenic formulation.

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The steps of a preferred embodiment of the present sacrosidase isolation and purification process are summarized in FIG. 1.

1. Digest yeast *saccharomyces cerevisiae* with papain in an aqueous buffered solution at a pH of about 7.0 and at a temperature of about 30-34° C.
2. The papain digestion cleaves all proteins into small molecular weight fragments that can later be effectively diafiltered away from the very large, papain resistant, sacrosidase enzyme, which in solution has an apparent native solution molecular weight of 500,000+ grams per mole (Daltons). Sacrosidase having the extensive glycosylation produced in yeast is resistant to papain digestion.
3. Use of diatomaceous earth with two different pore and/or particle sizes is preferred to remove most of the insoluble components, and likely other soluble and insoluble impurities. At the chosen pH, ionic strength, and concentrations, a large increase in purity occurs using these two steps in series that also prepares the resulting particulate free solution for diafiltration. Removal of insoluble components also prevents the dialysis membrane filters in the ultrafiltration unit from clogging. This increases the processing speed.
4. Diafiltration using an experimentally determined optimal pore size filter to balance purity with yield. The present process employs a minimum 40 kiloDalton cut-off filter to achieve an ultrapure hypoallergenic odorless solution of sacrosidase. The solution has a sacrosidase activity of at least about 22,000 IU/mL, preferably at least about 17,000 IU/mL. Larger pore filters give equivalent purity, but at the cost of yield. Smaller pore size filters do not provide sufficient final purity. Also experimentally determined was the number of batch volumes against which to diafilter: only 4+ diafiltration volumes allows for purity adequate to meet the requirements for a regulated bulk drug substance for human pharmaceutical use.
5. Final formulation of the drug substance with glycerol, preferably employs sterile filtration to ensure lot bioburden that meets FDA standards. The drug substance is stored in drums at about -18° C. to -25° C. for long term storage, until processed/concentration adjusted/packaged to yield the Sucraid® drug product. At this point, the sacrosidase activity is at least about 10,000 IU/mL.

The invention will be further described by reference to the following detailed examples, wherein the terms "SDS-PAGE" and "ELISA" as used herein are defined with reference to the following techniques.

Polyacrylamide Gel Electrophoresis (SDS-PAGE) Analysis

Samples of the sacrosidase bulk drug substance containing predetermined amounts of total protein, were analyzed by Charles Rivers Laboratory, Malvern, Pa. and the assays were validated by Tekagen, Inc., Malvern, Pa.

Reducing SDS-PAGE (sodium dodecyl sulfate-polyacrylamide gel electrophoresis) is used to separate mixtures of polypeptides (in an electric field) into distinct bands. Mobility under these conditions is primarily determined by molecular size. Staining with Colloidal Coomassie Blue allows for visual and/or densitometric analysis of the resolved bands. This method is linear for loads from 0.25µg to 15µg with a lower limit of detection of 0.1µg per band, e.g., the limits of detection and quantification of sacrosidase were determined to be 0.1 µg. The measured sacrosidase band area correlated linearly with the protein load.

In the assays herein below, the sacrosidase-containing samples described were reduced with 2-mercaptoethanol in SDS sample buffer. Samples were adjusted to about 1.0 mg/mL with water and treated with one volume of the mercaptoethanol in SDS buffer at 100° C. for 3 min. to denature/

reduce the protein. Samples were run in an XCell SureLock Mini-Cell® (Invitrogen) using Novex® 4.20% Tris-Glycine Gel (Invitrogen) using an SDS running buffer for 90 min. at 120 volts. Gels were stained with Coomassie Blue and washed in water. Gels were scanned using a Personal Densitometer SI (Molecular Dynamics).

Papain Quantification by Enzyme-Linked Immunosorbent Assay (ELISA)

Samples of the sacrosidase bulk drug substance were dialyzed against PBS and any papain was inhibited with E-64. The sample was assayed for papain content by Warnex Laboratories, Quebec, Canada, using a quantitative sandwich-type ELISA. A polyclonal capture antibody (rabbit) specific to papain is coated in each well of a microplate. When present in the samples, papain binds to the capture antibody. A second anti-papain antibody (goat) conjugated with horse-radish peroxidase (HRP) is added which binds to any captured papain. After washing, the O-phenylenediamine substrate is added with 0.03% H₂O₂ to produce an enzymatic color reaction with HRP. The reaction is stopped with a solution of sulfuric acid (stopping solution). The color intensity formed by the enzymatic reaction is measured by spectrophotometry.

The quantity of papain in the samples was calculated based on a standard curve, where the average OD values of each of the standards are on the Y-axis and the corresponding concentration of papain is on the X-axis. To determine the final concentration of papain in the samples the concentration obtained from the standard curve is multiplied by the dilution factor. The quantity of papain is calculated automatically by the Gen5 software. The lower limit of quantification of papain is 3.13 ng/mL. The lower limit detection of papain is 1.56 ng/mL.

EXAMPLE 1

Manufacturing Process for Ultrapure Sacrosidase

Deionized water (1700 kg) is charged to a 1000 gallon reactor and heated to 32±2° C. at which time *Saccharomyces cerevisiae* yeast (360 kg) is added and the slurry is mixed for 20-30 min. The pH is checked and if it is found to be below 6.9, the pH is adjusted using a 25% sodium hydroxide solution until the pH is 7.0±0.1.

Papain (3.4 kg) 100 TU/mg is added followed by hydrogen peroxide (35%, 2.8 kg). The slurry is stirred at 32±2° C. for the next 17.5 to 20 h; after every 3.5-4 h the pH is adjusted to 7.0±0.1 and hydrogen peroxide (34%, 2.8 kg each portion, 11.2 kg total) is added.

Once the 17.5-20 hours of mixing is complete the mixture is cooled to between 22° C. and 26° C. at which point 25 kg of 85% phosphoric acid is added over a 20-30 min period. The pH of the slurry is checked and the pH is further adjusted to 4.0±0.1 by addition of 85% phosphoric acid.

Diatomaceous earth (Celpure® S 1000, 210 kg) is added to the mixture followed by an additional 700 kg of deionized water and the slurry is mixed for 30-40 min. The slurry is filtered in four equal portions through a sparkler filter to remove the cell debris and any other solids from the product in solution. For each portion of the filtration, once the filtrate collection rate stops the filter bundle is washed with fresh deionized water (400 kg). These washes are combined with the initial filtrates.

After the fourth filtration is complete the combined filtrates and washes are returned to the 1000-gallon reactor and treated with hydrogen peroxide (34%, 2.0 kg). The solution is decolorized by treatment with activated carbon (20×40 mesh, 60 kg) and aluminum sulfate (9.4 kg); the resulting slurry is mixed for 1.5-2 h.

Diatomaceous earth (Celpure® S100, 32 kg) is added and mixed for an additional 30 min. The solids are removed by

filtration through the sparkler filter. The reactor is cleaned to remove any residual solids that may be present and the filtrate from decolorization is returned to the reactor through a 0.2-micron in-line filter. The solution is then concentrated to about 250 kg using an ultrafiltration unit that has been equipped with 40 kilo-Dalton cutoff filters.

The concentrated sacrosidase solution is then purified by diafiltration against at least four volumes (~1000 L) of citric acid buffer solution. This buffer solution is prepared from deionized water (1000 kg), citric acid (9.2 kg), sodium citrate (11.2 kg) and the pH of the solution is adjusted to 4.6±0.1 by addition of 25% sodium hydroxide. Additional volumes of buffer can be used to increase the overall protein purity while continuing to reduce residual levels of impurities in the final formulated solution. Typically four volumes (~1000 L) of citric acid buffer has been sufficient during diafiltration to purify the sacrosidase protein retained in the solution to >99% purity and to achieve papain levels <50 ppb.

Once the diafiltration is complete the solution is further concentrated until the material has an assay value ≥26,000 IU/mL in the sacrosidase assay test. The pH of the solution is then checked and adjusted to 4.3±0.1 by either use of 25% sodium hydroxide solution if the pH is <4.15 or by use of 85% phosphoric acid if the pH of the solution is >4.45.

Once the pH adjustment is complete the solution is transferred to a mixing vessel and an about equal weight of glycerin is added to produce the sacrosidase drug substance. The resulting water-glycerin solution is mixed for 10 min. The target drug substance has >10,000 IU/mL of sacrosidase and about 45-54 wt-% glycerol. Once the mixing is complete the solution is transferred to drums through two 0.2 micron nylon in-line filters that are set up in series. The drummed solution or "drug substance" is stored at room temperature for 8-36 h prior to being moved into long-term storage at about -20° C. Portions can be removed as needed and diluted and packaged to yield the Sucraid® drug product.

EXAMPLE 2

Coomassie Blue Stained Reduced SDS-PAGE Gel with Densitometry—Optimal Load

The gel shown in FIG. 2 is a Coomassie stained, reduced SDS-PAGE comparing 3 lots of a prior sacrosidase manufacturer (Lanes 3, 4, 5) that was manufactured with an older manufacturing process, with 3 lots of sacrosidase (Lanes 6, 7, 8) manufactured using the new ultra-pure hypoallergenic manufacturing process. Reference standard C4546 is the reference standard currently in use and was produced from the older process. Reference standard C3955 is an older-yet reference standard from the original Sacrosidase manufacturer.

The densitometry scan of this optimally loaded SDS-PAGE gel is shown below (Table 1). These results clearly show that the sacrosidase manufactured using the new process is ultrapure with no detectable protein impurities. The cGMP validation of this method established a limit of detection of less than 0.1 micrograms.

TABLE 1

Sample Type	Lot Number	Lane No.	Band No.	Band Volume	% Density
Reference	C4546	2.	1.	1823	94.31
Standard		2.	2.	110	5.69
Old Process	STS-199NS	3.	1.	2376	94.93
		3.	2.	127	5.07
Old Process	STS-220NS	4.	1.	2822	94.83
		4.	2.	154	5.17
Old Process	STS-241NS	5.	1.	2590	94.46
		5.	2.	152	5.54

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TABLE 1-continued

Sample Type	Lot Number	Lane No.	Band No.	Band Volume	% Density
New Process	125275	6.	1.	2356	>99.9
New Process	125434	7.	1.	2331	>99.9
New Process	125722	8.	1.	2159	>99.9
Reference Standard*	C3955	9.	1.	2256	>99.9

*Purified by chromatography. Experimental sample only.

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EXAMPLE 3

Coomassie Stained Reduced SDS-PAGE Gel with Densitometry—Overloaded Gel

In a second protocol reduced SDS-PAGE gels were overloaded with 20 µg of protein (FIG. 3). In the Coomassie stained gels, a small impurity band is visible in the present sacrosidase drug substance, but the absolute purity of the sacrosidase of the invention (~97%, Lanes 6, 7, 8) is still superior to the older sacrosidase (~90%, Lanes 3, 4, 5). Table 2 summarizes the information from this gel.

TABLE 2

Sample Type	Sample Lot	Protein Qty (µg)	Lane No.	Band No.	Band rf	Band Volume	Band Sum	% Density
Reference Standard	C4546	20	2.	1.	0.151	4419	4867	90.80
Old Process	STS-199NS	20	2.	2.	0.561	448		9.20
Old Process	STS-220NS	20	3.	1.	0.145	5063	5588	90.60
Old Process	STS-241NS	20	3.	2.	0.568	525		9.40
New Process	125275	15	4.	1.	0.132	5460	5969	91.47
New Process	125434	15	4.	2.	0.559	509		8.53
New Process	125722	15	5.	1.	0.132	4577	5003	91.49
New Process	125434	15	5.	2.	0.550	426		8.51
New Process	125722	15	6.	1.	0.126	5157	5292	97.45
New Process	125434	15	6.	2.	0.542	135		2.55
New Process	125722	15	7.	1.	0.134	4820	4936	97.65
New Process	125722	15	7.	2.	0.546	116		2.35
New Process	125722	15	8.	1.	0.128	4832	4931	97.99
New Process	125722	15	8.	2.	0.550	99		2.01
Reference Standard	C3955	15	9.	1.	0.257	5640	6326	89.16
Reference Standard	C3955	15	9.	2.	0.450	69		1.09
Reference Standard	C3955	15	9.	3.	0.490	135		2.13
Reference Standard	C3955	15	9.	4.	0.554	108		1.71
Reference Standard	C3955	15	9.	5.	0.609	96		1.52
Reference Standard	C3955	15	9.	6.	0.669	143		2.26
Reference Standard	C3955	15	9.	7.	0.732	135		2.13

EXAMPLE 4

Optimal and Overloaded Native Gels

In a third protocol non-reduced samples were run on native PAGE gels. Both optimal (5 µg protein) and overloaded (20, 30 & 60 µg protein) protein were applied to polyacrylamide gels then stained with Coomassie Blue.

FIG. 4 depicts an overloaded (15 µg) Coomassie stained native gel. Densitometry scanning of the gel show purity values of 97.59, 99.02, and 99.31 for sacrosidase made by the older sacrosidase process and 100%, 100% and 100% for the sacrosidase manufactured using the present ultrapure process. This gel clearly demonstrates the ultrapure quality of the sacrosidase manufactured using the new process. Table 3 summarizes the information from this gel.

TABLE 3

Sample Type	Sample Lot	Protein Qty (µg)	Lane No.	Band No.	Band rf	Band Volume	Band Sum	% Density
Reference	C4546	15	1.	1.	0.170	10034	10167	98.69
Reference	C4546	15	1.	2.	0.492	62		0.61
Reference	C4546	15	1.	3.	0.711	71		0.70
Old Process	STS-199NS	15	2.	1.	0.115	8926	9146	97.59
Old Process	STS-199NS	15	2.	2.	0.495	51		0.56
Old Process	STS-199NS	15	2.	3.	0.689	86		0.94
Old Process	STS-199NS	15	2.	4.	0.896	83		0.91
Old Process	STS-220NS	15	3.	1.	0.120	8473	8557	99.02
Old Process	STS-220NS	15	3.	2.	0.679	84		0.98
Old Process	STS-241NS	15	4.	1.	0.150	8670	8730	99.31
Old Process	STS-241NS	15	4.	2.	0.662	60		0.69

TABLE 3-continued

Sample Type	Sample Lot	Protein Qty (µg)	Lane No.	Band No.	Band rf	Band Volume	Band Sum	% Density
New Process	125275	15	5.	1.	0.166	9100	9100	100
New Process	125434	15	6.	1.	0.129	7967	7967	100
New Process	125722	15	7.	1.	0.141	8605	8605	100
Reference	C3955	15	8.	1.	0.190	13693	13744	99.63
			8.	2.	0.573	51		0.37

EXAMPLE 5

Three Order of Magnitude (1,000 fold) Reduction in a Protein Impurity

The FDA recalled all topical papain products in 2008 due to risk of hypersensitivity reactions (www.fda.gov/NewsEvents/Newsroom/PressAnnouncements/2008/ucm116956.htm) and a REMS was required for sacrosidase that same year (www.fda.gov/downloads/Drugs/DrugSafety/PostmarketDrugSafetyInformationforPatientsandProviders/UCM144251.pdf). The present process demonstrates an impressive three order of magnitude reduction in the papain levels of the drug substance to nearly undetectable levels with a very sensitive ELISA (LOQ of 3 ng/mL) using this new chromatography-free process. LOQ is the limit of quantitation. These lots below were the end result of three process validation lots from the present process (Lots 125275, 125897, 125907) versus the old manufacturer lots (STS-199NS, STS-220NS, STS-241NS) which carried an FDA imposed papain limit of 10,000 ng/mL.

TABLE 4

Sacrosidase lot number with papain concentration underneath in ng/mL					
STS-199NS	STS-220NS	STS-241NS	125275	125897	125907
7300	8050	5470	<3	<3	<3

This example shows the substantial level of reduction of papain to undetectable levels. Papain at 23 kilo-Daltons is a key marker protein that is likely representative of any other proteins below the 40 KD cutoff limit of the ultrafiltration filter used, along with the proteins cleaved by papain that fall above the 40 KD molecular weight cut-off, with the exception of sacrosidase which is resistant to papain cleavage in its three dimensional native form in solution.

EXAMPLE 6

Organoleptic Properties Improved

While diafiltering the solution after concentration, an operator was tasked with observing the color and smell of the concentrated sacrosidase solution. As the number of wash volumes increased from no (zero) diafiltration wash volumes

up to four (4) diafiltration wash volumes, the operator observed that all yeast smell was removed from the sacrosidase solution and the yellow color was dramatically reduced to almost no yellow color. These organoleptic properties of this new ultrapure formulation are important for young pediatric patient compliance as the “yeasty smell” is not tolerated well by some young patients leading to poor compliance with their prescribed Sucraid dosing.

EXAMPLE 7

Clinical Evidence of Improved Safety and Continued Efficacy

A 5 year old female CSID patient was first dosed with the old formulation of Sucraid in August 2012, and as instructed by the FDA approved labeling (package insert) due to the possibility of allergic reactions, she was dosed the first time within her physicians’ offices. This patient manifested a whole body case of hives immediately after dosing with the old formulation of Sucraid. Further dosing with Sucraid was therefore precluded. The family was eager to find a solution to their daughters gastrointestinal problems, so acceded to a second challenge with different lot of the old formulation of Sucraid about 2 months later. Again, hives manifested, and so this patient was permanently precluded from using the commercially marketed FDA approved Sucraid to treat her genetically determined sucrase deficiency.

After this new ultrapure hypoallergenic formulation of sacrosidase was developed, an IND was filed and authorized by FDA, along with Institutional Review Board (IRB) approval at the Mayo Clinic in Rochester Minnesota for a test dosing protocol in this same patient in November 2013. After treatment with the new ultrapure hypoallergenic formulation of sacrosidase, this 5 year old patient no longer manifested allergic reactions or symptoms, including hives. Further, after taking the new ultrapure hypoallergenic formulation of Sucraid her CSID symptoms were completely ameliorated, including normalizing to 1-2 formed stools per day versus >6+ watery diarrhea type bowel movements per day, elimination of her abdominal pain, and elimination of her abdominal distension, so that this pediatric patient is now able to utilize this life changing medication to treat her disease. The new ultrapure hypoallergenic formulation of sacrosidase is being provided to this patient for chronic use pursuant to an FDA approved IND along with Mayo IRB approval with excellent results for control of her CSID disease.

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Asp Ala Lys Trp His Leu Tyr Phe Gln Tyr Asn Pro Asn Asp Thr Val
 35             40             45

Trp Gly Thr Pro Leu Phe Trp Gly His Ala Thr Ser Asp Asp Leu Thr
 50             55             60

Asn Trp Glu Asp Gln Pro Ile Ala Ile Ala Pro Lys Arg Asn Asp Ser
 65             70             75             80

Gly Ala Phe Ser Gly Ser Met Val Val Asp Tyr Asn Asn Thr Ser Gly
 85             90             95

Phe Phe Asn Asp Thr Ile Asp Pro Arg Gln Arg Cys Val Ala Ile Trp
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Thr Tyr Asn Thr Pro Glu Ser Glu Glu Gln Tyr Ile Ser Tyr Ser Leu
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Phe Ile Ser Ile Asn Pro Gly Ala Pro Ala Gly Gly Ser Phe Asn Gln
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245            250            255

Gln Ser Arg Val Val Asp Phe Gly Lys Asp Tyr Tyr Ala Leu Gln Thr
260            265            270

Phe Phe Asn Thr Asp Pro Thr Tyr Gly Ser Ala Leu Gly Ile Ala Trp
275            280            285

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290            295            300

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305            310            315            320

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			500					505					510			

Lys

What is claimed is:

1. Hypoallergenic sacrosidase prepared by a process comprising:

- (a) digesting an aqueous suspension of *saccharomyces cerevisiae* at a pH of about 7.0 with an amount of papain effective to cleave non-sacrosidase proteins in said suspension while not cleaving sacrosidase in said suspension;
- (b) acidifying and filtering the digested suspension to remove cell debris yield an acidified filtrate;
- (c) treating the acidified filtrate with one or more decolorizing agents to yield a decolorized suspension;
- (d) filtering and concentrating the decolorized suspension to yield a concentrated sacrosidase solution;
- (e) diafiltering the concentrated sacrosidase solution to yield a solution of-hypoallergenic sacrosidase, wherein

the primary structure of the sacrosidase is a 513 amino acid polypeptide that is glycosylated, and wherein the solution has a sacrosidase activity of at least about 22,000 IU/mL in water at a pH of about 4.6 \pm 0.1 and has a residual papain level of less than about 50 ppb (50 nanograms/mL) papain.

2. The sacrosidase of claim 1 wherein step (d) comprises sparkler filtration followed by ultrafiltration.

3. The sacrosidase of claim 1 wherein the decolorizing agent comprises activated charcoal.

4. The sacrosidase of claim 1 wherein the diafiltration is carried out against four or more volumes of citrate buffer.

5. The sacrosidase of claim 1 further comprising adding about 45-54 wt-% glycerol to the aqueous solution of sacrosidase.

* * * * *